

Date: Tuesday, 1/2/2007 1:28:51 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
<b>Job Number</b>	: 30096	<b>Part Number</b>	: D2573		
<b>Estimate Number</b>	: 10533	<b>Drawing Number</b>	: D2573 REV E		
<b>P.O. Number</b>	: N/A	<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 1/2/2007	<b>Type</b>	: MACHINED PARTS		
<b>Prsht Rev.</b>	: NC	<b>Material</b>	: N/A		
<b>First Issue</b>	: N/A	<b>Due Date</b>	: 1/9/2007		
<b>Previous Run</b>	: 29662	<b>Qty:</b>	12		
<b>Written By</b>	: <i>J.F.</i>	<b>Um:</b>	Each		
<b>Checked &amp; Approved By</b>	: <i>J.F.</i>				
<b>Comment</b>	: Est: I As Per RevE 06-01-27 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B25333</u> * 12	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>B30076</u> Double check by: <u>J.F.</u>  1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 DQA: Date:  07/01/22

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30096

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En/J.F. 07/01/18 (12)

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SD 07.01.18

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

83/4L

07.01.18 (12)

7.0 POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

5/1/a.m

07/01/19 (12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 07/01/22 (12)



9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5471

07/01/22 (12)



10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



07/01/22 (12)

Job Completion



C 07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD				Work Order:	30096
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.446	0.446	0.446		
B	1.745	1.755		1.750	1.749	1.748	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.748	1.747		
E	7.990	8.010		8.000	8.002	8.002	8.003		
F	0.490	0.510		0.496	0.502	0.501	0.499		
G	0.257	0.262	DT8683	0.260	0.266	0.266	0.266		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.507	0.502	0.504	0.504		
J	1.174	1.184		1.177	1.177	1.178	1.176		
K	0.558	0.578		0.567	0.566	0.568	0.570		
L	1.174	1.184		1.177	1.177	1.178	1.176		
M	1.365	1.375		1.367	1.369	1.369	1.369		
N	2.495	2.505		2.497	2.498	2.499	2.501		
O	4.119	4.129		4.122	4.122	4.123	4.120		
P	0.115	0.135		0.127	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.133		
R	0.240	0.260		0.255	0.256	0.249	0.250		
S	0.115	0.135		0.124	0.125	0.125	0.126		
T	0.178	0.198		0.182	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.245	0.239	0.240	0.237		
W	0.115	0.135		0.126	0.125	0.125	0.126		
X	0.308	0.313		0.310	0.310	0.309	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.366	0.366	0.366		
AA	0.470	0.530		0.506	0.500	0.500	0.500		
AB	0.615	0.635		0.679	0.679	0.678	0.677		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.251	0.251	0.246		
AE	1.500	1.520		1.509	1.510	1.509	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.246	0.246	0.245		
AI	2.000	2.020		2.000	2.000	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP	Audited by:	J.F.
Date:	07/01/13	Date:	07/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM

DART AEROSPACE LTD			Work Order:	30096
Description: Saddle, Aft Outboard			Part Number:	D2573
Inspection Dwg: D2573 Rev. E			Page 1 of 1	

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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.747	1.750		
C	3.495	3.505		3.498	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.747	1.750		
E	7.990	8.010		8.003	8.003	8.004	8.003		
F	0.490	0.510		0.499	0.498	0.498	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.504	0.504	0.506	0.505		
J	1.174	1.184		1.176	1.177	1.177	1.177		
K	0.558	0.578		0.567	0.568	0.567	0.567		
L	1.174	1.184		1.176	1.177	1.177	1.177		
M	1.365	1.375		1.366	1.371	1.371	1.371		
N	2.495	2.505		2.498	2.498	2.498	2.498		
O	4.119	4.129		4.123	4.120	4.120	4.120		
P	0.115	0.135		0.127	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.250	0.250		
S	0.115	0.135		0.126	0.121	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.236	0.238	0.237		
W	0.115	0.135		0.122	0.124	0.122	0.123		
X	0.308	0.313		0.310	0.309	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.369	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.629	0.629	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	0.245	0.244		
AE	1.500	1.520		1.513	1.512	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.249	0.248		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	SJ	Audited by:	J.F.
Date:	07/01/15	Date:	07/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SP

DART AEROSPACE LTD	Work Order:	30096
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

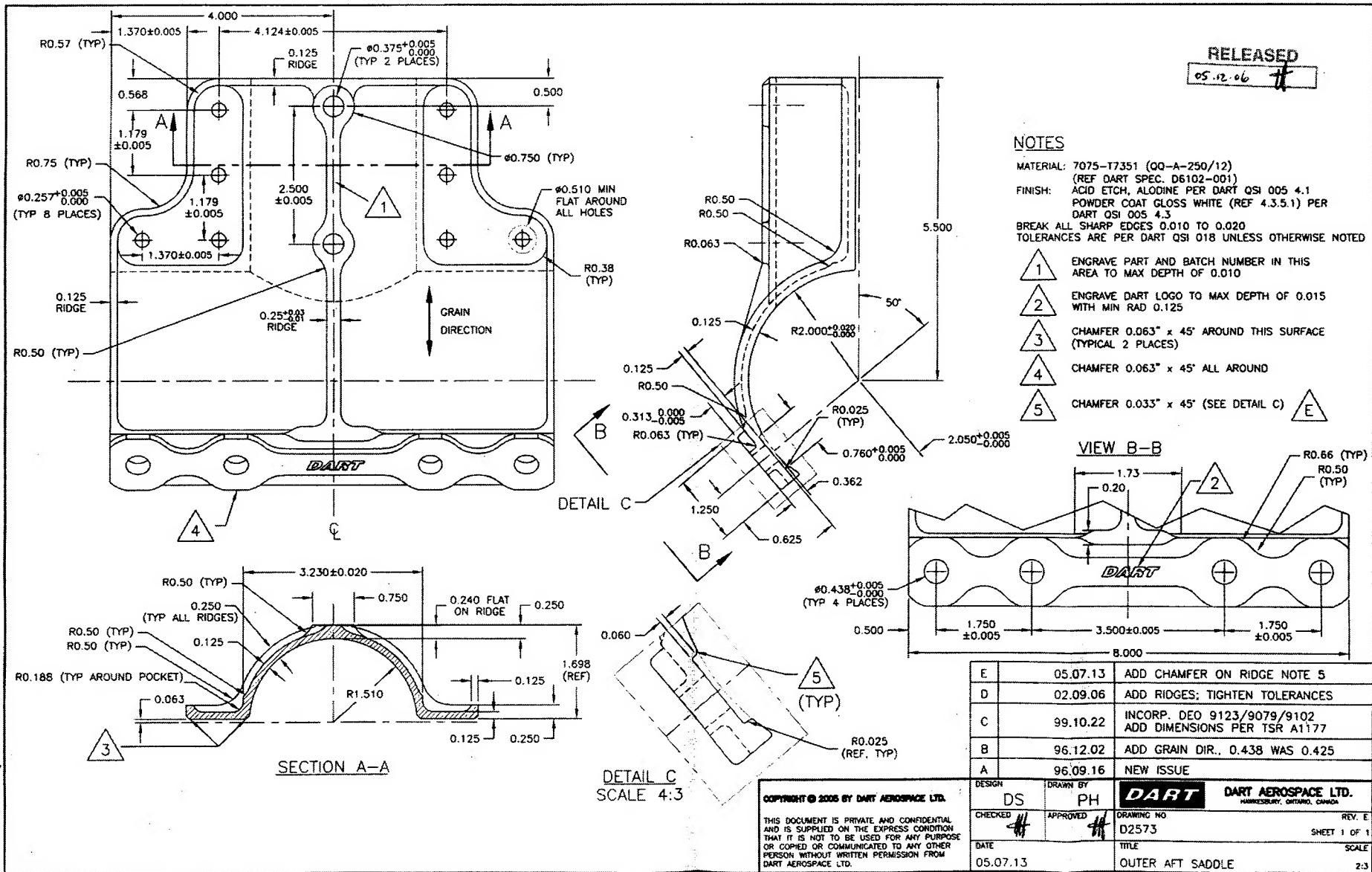
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.750	1.754"		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.754		
E	7.990	8.010		8.005	8.004	8.004	8.002		
F	0.490	0.510		0.499	0.499	0.498	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.502	0.504	0.501	0.505"		
J	1.174	1.184		1.177	1.177	1.177	1.177"		
K	0.558	0.578		0.567	0.568	0.567	0.570"		
L	1.174	1.184		1.177	1.177	1.177	1.177"		
M	1.365	1.375		1.369	1.370	1.365	1.373		
N	2.495	2.505		2.500	2.500	2.500	2.500"		
O	4.119	4.129		4.120	4.120	4.120	4.126		
P	0.115	0.135		0.126	0.126	0.127	0.128"		
Q	0.115	0.135		0.135	0.135	0.135	0.135"		
R	0.240	0.260		0.250	0.251	0.250	0.250"		
S	0.115	0.135		0.125	0.126	0.124	0.127"		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.238	0.238	0.244		
W	0.115	0.135		0.125	0.124	0.124	0.126		
X	0.308	0.313		0.310	0.310	0.310	0.311"		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.366	0.366	0.372"		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.626	0.627	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.245	0.249		
AE	1.500	1.520		1.511	1.511	1.510	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.249	0.253		
AI	2.000	2.020		2.000	2.000	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	EJ / JF	Audited by:	SD
Date:	07/01/16	Date:	01.01.16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM

RELEASED  
05.12.06



05.07.10.102